

Work Order ID 147751

June 10, 2016 4:04:06 PM

Ship July 14/
147751

Page 1

Item ID: D350-591-311 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/10/2016 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 7/14/2016 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: SA Date: 6/10/16 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3272	Rev B								

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								

110	Large Fab	0.00							
110	Large Fab								
Large Fab	Memo	0.80							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>134826</u>								
	3-Grind End Plate flush								

B147751 {X15LH}

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Hand Finishing

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 6/10/2016 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 7/14/2016 Req'd Qty: 15.00 ***15*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						15	JUL 05 2016		DAS 24 8-89
QC	Memo	0.03							
Quality Control									
180		0.00							
180	Large Fab								DAS 24 8-89
Large Fab	Memo	0.70							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod _____								DAS 24 8-89
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

C. J.

C. J.

15 *7-11-2016* *C. J.*

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
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Work Order ID 147751

147751

Page 4

June 10, 2016 4:04:07 PM

Item ID: D350-591-311
 Revision ID:
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/10/2016 Start Qty: 15.00
 Required Date: 7/14/2016 Req'd Qty: 15.00
 Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(15)			DAS 38 9-89 JUL 11 2016
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.05				(15)			DAS 38 9-89 JUL 11 2016
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.18				(15)			206/07/12 BEB.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 147751

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/10/2016 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 7/14/2016 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220	<i>m 134798.</i>					<i>15</i>	<i>6</i>	<i>16-07-14</i>	<i>333</i>
Powdercoat	Memo	0.43							
Powder Coating	START TIME: <i>11:00</i>								
	OVEN TEMPERATURE: <i>320</i>								
	FINISH TIME: <i>11:30</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch <i>113490</i>								
230									
HandFinish	Memo	0.48							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.03							
Quality Control									

x1544 c 16/07/15

(15)

DAS
38
9-89

JUL 19 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :			
Misidentified ☐		Past Due ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

Work Order ID 147751

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147751

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Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***

Start Date: 6/10/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/14/2016 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280**DAS****21****JUL 20 2016**

QC

Memo

0.25

9-89

Quality Control

u 16-07-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

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147751

D350-591-311

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	DAS 24 3-89
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------	-------------------

1 15
 ** B146690 - 15 JUN 30 2016

1 15 DAS
** JUN 30 2016 24
9-20

WA003	91
142780	5
146702	86

2 30 JUN 30 2016 DAS 24 9-89

WA003	60
142668	40
<u>144410</u>	20

2 30 DAS
** JUN 30 2016 24
8-00

146104 ~~JUN 30 2010~~ 9-00
30 C 16-07-05

Picklist Print

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Page 2

Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS20600-AD4W4

Purchased

No

180

Each

2,024.000

16

240

MS20600-AD4W4

Rivets

**

240 C 16-07-05

Location

Loc Qty

Loc Code

CCK005

1982

M133990

1482

M134955

500

ST308

42

M132640

42

D3065-041

Manufactured

No

180

Each

7.0000

1

15

D3065-041

Step Leg Assembly

B147351

**

15 16-07-05

Location

Loc Qty

Loc Code

WA002

7

144118

3

144982

1

145083

3

D3067-1

Manufactured

No

180

Each

91.0000

1

15

D3067-1

End Plate

**

GPC

Location

Loc Qty

Loc Code

WA003

91

142780

5

146702

86

B145081 → 6

Picklist Print

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Page 3

Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

AN3-35A
AN3-35A
Bolt

Purchased No 250 Each 217.0000 2 30

**

Pc 

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	10	
122800	10	
over003	100	
m134943	100	
ST348	107	
m134167	50	
m134497	57	

D3235-1
D3235-1
Mounting Lug

Manufactured No 250 Each 70.0000 2 30

**

B141127x1 Pc

DAS
27
9-89

Location	Loc Qty	Loc Code
ST521	20	
143809	20	
ST546A	50	
142565	50	

D3278-041
D3278-041
Support Assembly

Manufactured No 250 Each 23.0000 1 15

**

x3 B145581 Pc 

DAS
27
9-89

Location	Loc Qty	Loc Code
ST522	23	
145580	23	

12

JUL 12 2016

Picklist Print

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Page 4

Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

NAS1149D0463J

Purchased

No

250

Each

3,625.000

16

240

NAS1149D0463.I

WASHER

**

PS
DAS
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	86	
M132035	21	
M134508	65	
ST260a	2000	
M134852	1000	240
M134943	1000	
ST263	1539	
M134754	1539	

NAS1149D0563J

Purchased

No

250

Each

957.0000

4

60

NAS1149D0563.I

Washer

**

Pc

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	231	
m125807	2	
m133769	229	
ST263	627	
m134497	627	60
ST269	99	
m128257	99	

AN5-36A

Purchased

No

250

Each

167.0000

2

30

AN5-36A

Bolt

**

Pc

DAS
27
9-89

Location

Loc Qty

Loc Code

over004	120	
M134861	120	30
ST336	47	
M130466	15	
M134676	32	

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Shop Packet Print

June 12, 2016

Picklist Print

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Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

D2618 Manufactured No 250 Each 139.0000 2 30

D2618

Bushing

DAS
27
9-89

**

PC



Location Loc Qty Loc Code

ST008A 139
144670 39
146622 100

D2230-3 Manufactured No 250 Each 175.0000 4 60

D2230-3

Mounting Lug

DAS
27
9-89

**

PC



Location Loc Qty Loc Code

FG 8
109344 4
89045 4
ST521 67
142522 1
143805 66
ST525A 100
144487 60
145363 40

D2856-400-720 Manufactured No 250 Each 156.0000 2 30

D2856-400-720

Abrasion Strip 4" X 7.20"

**

PC



Location Loc Qty Loc Code

FG 14
134509 4
137049 10
ST418 142
141946 5
146220 137

DAS
27
9-89

JUL 12 2016

June 10, 2016 4:04:12 PM

Shop Packet Print

Page 5

Picklist Print

June 10, 2016 4:04:12 PM

Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS21042L3

Purchased

No

250

Each

1,778.000

2

30

MS21042L3

Nut



Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

865

m134039

12

m134634

53

m134943

800

DAS
27
9-89

AN4-13A

Purchased

No

250

Each

732.0000

8

120

AN4-13A

Bolt



Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

over003

500

m134852

400

m134943

100

ST344

152

m134754

152

DAS
27
9-89

JUL 11 2016

Picklist Print

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Page 7

Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS21042L5

Purchased

No

250

Each

583.0000

2

30

MS21042L5

Nut

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

GA	95	
m127813	95	
OVER007	250	
m134509	100	
m134955	150	
ST303	238	
m134055	6	
m134676	32	
m134762	200	

MS21042L4

Purchased

No

250

Each

2,264.000

8

120

MS21042L4

Locknut

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

GA	181	
m133769	181	
OVER007	1000	
m134861	1000	
ST303	989	
m134762	489	
m134955	500	
ST305	94	
m130922	94	

77 38

82

JUL 12 2016

Picklist Print

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Work Order ID: 147751

147751

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

NAS1149D0363J

Purchased

No

250

Each

2,284.000

4

60

NAS1149D0363.J

Washer

**

PC



Location

Loc Qty

Loc Code

GA	465	
m134055	465	
ST263	1819	
m134606	8	
m134676	811	
m134955	1000	

DAS
27
9-89

60

JUL 12 2016

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

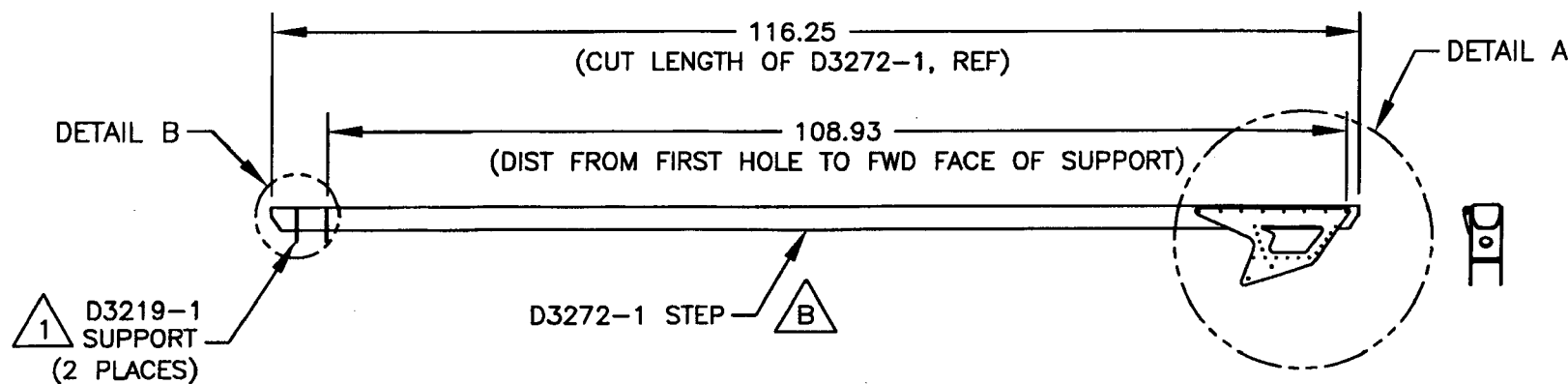
SH 147751
6/10/16

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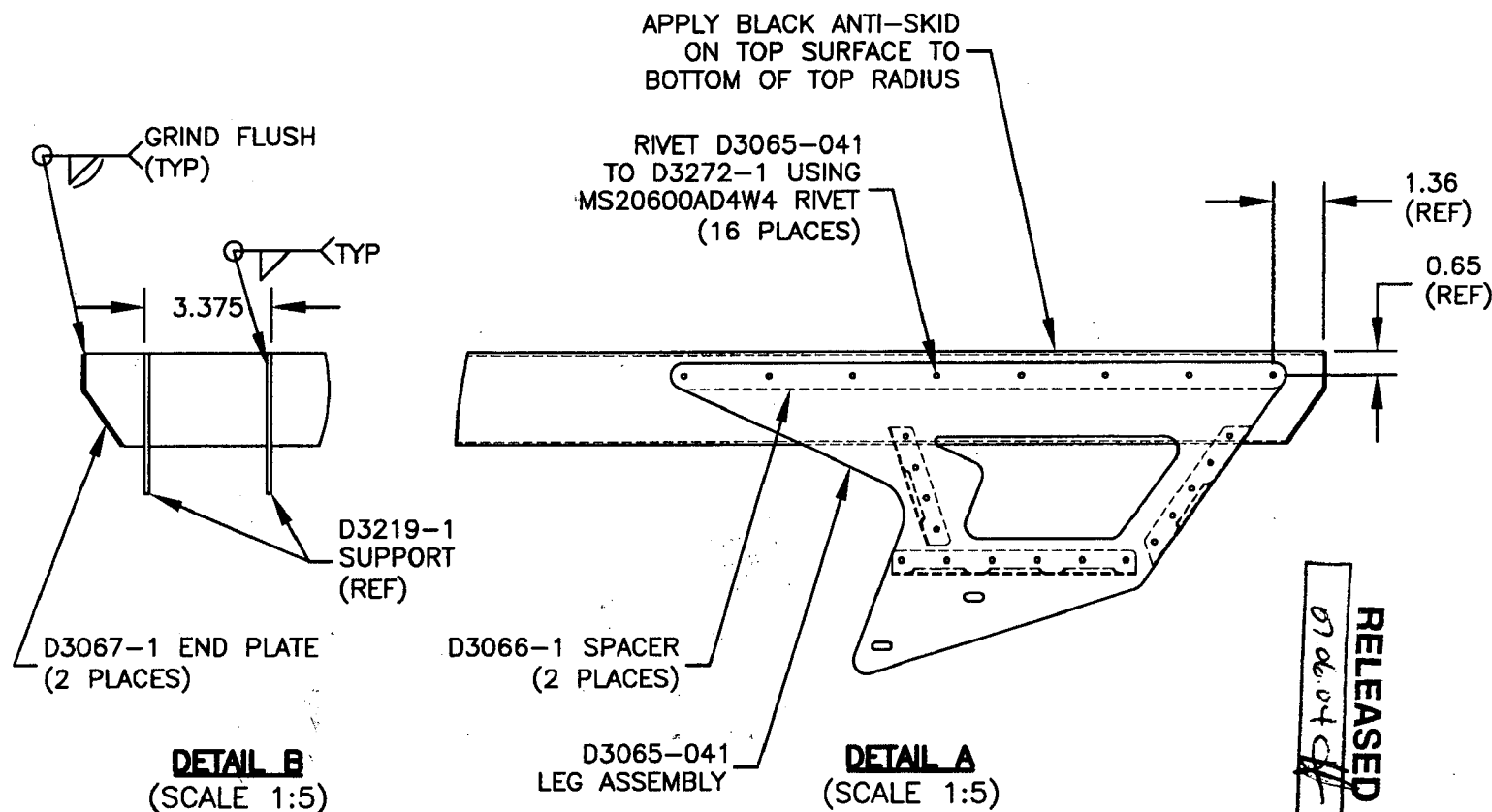
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

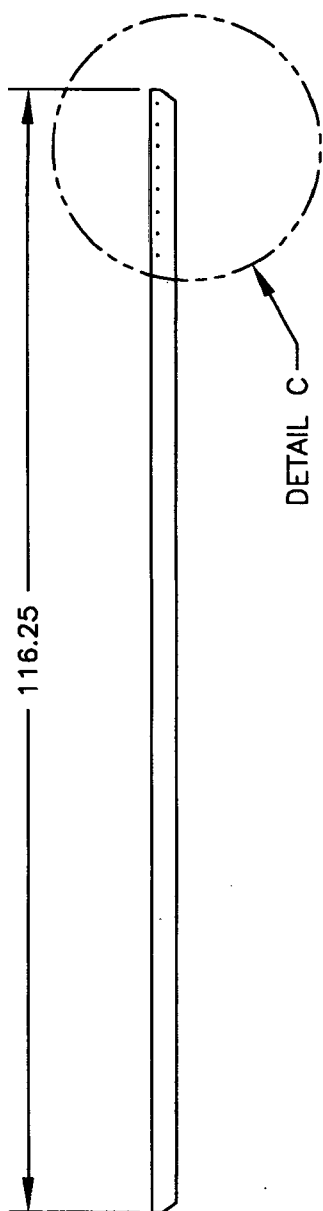




DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

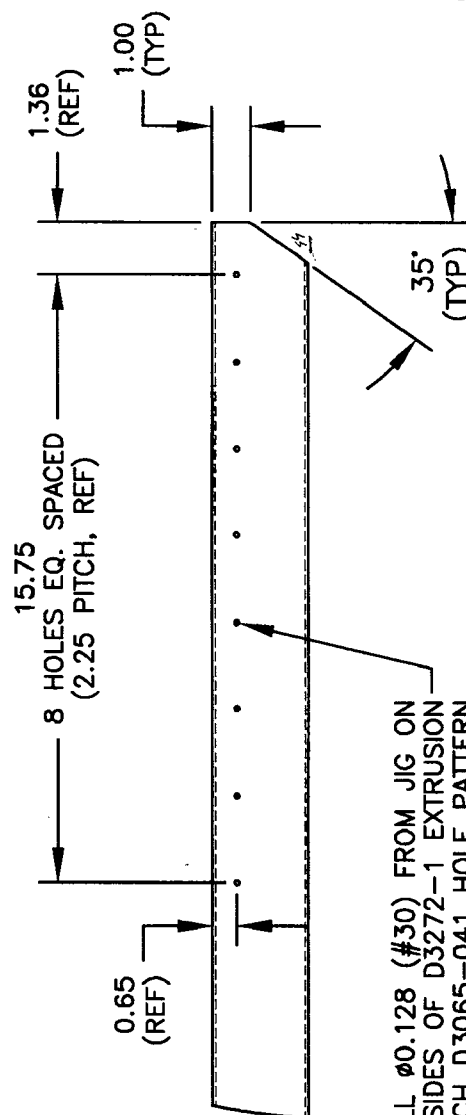
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.